



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
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Tel (613) 632-5200

**D4417-041**  
**Job Sheet 178111**



Part No: D4417-041

Job Qty: 1 ea

Part Name: Step Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 5/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEETS 3,4 IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC IPP REV:B 11.08.17 PER REV.B. DD VERF:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off      |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|---------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |               |
| 90    | Start up Operation | 1 Ea  |            | 5/31/18  | 0.00      | 0.00    | Start Up Large Fab-4  |           | DC 0018-05-29 |
| 100   | Large Fab          | 1 pcs |            | 5/31/18  | 0.00      | 1.76    | Large Fab 8           |           | DC 0018-05-29 |
| 120   | QC                 | 1 pcs |            | 5/31/18  | 0.00      | 0.00    | QC5                   |           | CPL           |
| 130   | HandFinish         | 1 pcs |            | 5/31/18  | 0.00      | 0.36    | HandFinish1           |           | SA 18-05-30   |
| 140   | QC                 | 1 pcs |            | 5/31/18  | 0.00      | 0.00    | QC7-3                 |           | CPL           |
| 150   | Large Fab          | 1 pcs |            | 5/31/18  | 0.00      | 1.76    | Large Fab 2           |           | SA 18-06-12   |
| 160   | QC                 | 1 pcs |            | 5/31/18  | 0.00      | 0.00    | QC10                  |           | SA 18-06-12   |
| 170   | QC                 | 1 pcs |            | 5/31/18  | 0.00      | 0.00    | QC5                   |           | SA 18-06-12   |
| 180   | Powdercoat         | 1 pcs |            | 5/31/18  | 0.00      | 0.26    | Powdercoat1           |           | SA 18-06-13   |
| 190   | HandFinish         | 1 pcs |            | 5/31/18  | 0.00      | 0.36    | HandFinish3           |           | SA 18-06-13   |
| 200   | QC                 | 1 pcs |            | 5/31/18  | 0.00      | 0.00    | QC3                   |           | SA 18-06-13   |
| 210   | Packaging          | 1 pcs |            | 5/31/18  | 0.00      | 0.00    | Packaging3-2          |           | SA 18-06-13   |
| 220   | QC21-SA            | 1 Ea  |            | 5/31/18  | 0.00      | 0.00    | QC21                  |           | SA 18-06-13   |

Part Op 100 - 1-Cut D2622 to 106"AS PER DWG 2-DRILL HOLES USING DT9765 3-CUT ENDS AT 45 DEG AS PER DWG  
Descriptions: 150 - 1-SWAGE TUBES AS PER DWG 2-Weld cap per dwg D4417 3-grind flush  
180 - 1-Touch up alodine  
220 - 4- OPEN HOLES AT 0.508" AS PER DWG

MB8839 START: 8:15 A.T. 500 FINISH: 8:45

### Job BOM

| Part / Item | Component Name | Quantity    | Operation             | Container |
|-------------|----------------|-------------|-----------------------|-----------|
| D2622-120C  | Step Extrusion | 1 Ea (1 ea) | 90-Start up Operation | SC46116   |
| D2734       | Step End Plate | 2 Ea (2 ea) | 150-Large Fab         | 5063695   |
| D4425-1     | Step Spacer    | 2 Ea (2 ea) | 150-Large Fab         | 5140054   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D2622-120C     | 1        | 121       | 0         |
| 150-Large Fab         | D2734          | 2        | 22        | 0         |
|                       | D4425-1        | 2        | 8         | 0         |

### Part Specifications

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                      |                                     |                                                                                                                                                                                |                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
|------------------------------------------------------|-------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|-----------------------|--|--|------------------------------------|-------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------------|----------------------------------|----------------------------------------|------------------------------------|----------------------------------------------|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br>Part No. _____<br>NCR No. _____ |                                     | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><table> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Cross tube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |  |  |                       |  |  | Skid-tube <input type="checkbox"/> | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                   | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/>                                                                                                                                             | Engineering <input type="checkbox"/> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                   | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>                                                                                                                                     | Quality <input type="checkbox"/>     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>               | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>                                                                                                                                   | Other <input type="checkbox"/>       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                   | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>                                                                                                                                              |                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Date :                                               |                                     | Step #:                                                                                                                                                                        |                                      | QTY Effective :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  | MRB (QSI042) Approval |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Description Work Order Deviation                     |                                     |                                                                                                                                                                                |                                      | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
|                                                      |                                     |                                                                                                                                                                                |                                      | Completed By                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
|                                                      |                                     |                                                                                                                                                                                |                                      | Lead hand / Supervisor Approval Verification                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
|                                                      |                                     |                                                                                                                                                                                |                                      | QC / QA Coordinator Approval                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |

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Container No: S075512

Part: D4417 - 041

Job No: 178111

Serial No/Batch: S075512

Revision:

Inspector:

Date: 05/29/18

### FAULT CATEGORY

|                                                |                                             |                                               |
|------------------------------------------------|---------------------------------------------|-----------------------------------------------|
| fect<br>te/Unqualified                         | <input type="checkbox"/> Power Loss/Surge   | <input type="checkbox"/> Positioned Wrong     |
|                                                | <input type="checkbox"/> Folio/Program      | <input type="checkbox"/> Outside Dimensions   |
|                                                | <input type="checkbox"/> Grain              | <input type="checkbox"/> Over/Under tolerance |
|                                                | <input type="checkbox"/> Weld               | <input type="checkbox"/> Part Incorrect       |
|                                                | <input type="checkbox"/> Wrong Stock Pulled | <input type="checkbox"/> Part Lost/Missing    |
|                                                | <input type="checkbox"/> Out of Sequence    | <input type="checkbox"/> Part Moved           |
|                                                | <input type="checkbox"/> Off-set            | <input type="checkbox"/> Drawing              |
|                                                | <input type="checkbox"/> Misabeled          | <input type="checkbox"/> Finish               |
|                                                | ete/Unclear                                 | <input type="checkbox"/> Fit/Function         |
| <input type="checkbox"/> Misaligned/off center |                                             | <input type="checkbox"/> Turning Sequence     |